

Serial No. 10/774,143  
Reply to Office Action of November 21, 2005

**Amendments to the Claims:**

This listing of claims will replace all prior versions and listings of claims in the application:

**Listing of Claims:**

Claims 1-16 (Cancelled)

Claim 17 (Withdrawn): A method of manufacturing a disk drive, comprising:

    a single molding step to form an enclosure including a base, a cover and a hinge mechanically coupling the base to the cover such that the hinge forms a portion of an exterior surface of the enclosure;

    attaching a spindle motor to the base;

    mounting a disk to the spindle motor, and

    pivotally coupling a head stack assembly pivotally to the base.

Claim 18 (Withdrawn): The method of Claim 17, wherein the molding step is an insert-molding step.

Claim 19 (Currently Amended): A method of manufacturing a disk drive, comprising:

    providing a base;

    providing a cover;

    molding a hinge formed of a flexible material onto an exterior surface of the base and onto an exterior surface of the cover to mechanically couple the base to the cover such that the hinge forms a portion of an exterior surface of [[the]] an enclosure defined by the base, the cover, and the hinge;

    attaching a spindle motor to the base;

    mounting a disk to the spindle motor, and

    pivotally coupling a head stack assembly pivotally to the base.

Claim 20 (Original): The method of Claim 19, wherein the molding step is an insert-molding step.

Serial No. 10/774,143  
Reply to Office Action of November 21, 2005

**Claim 21 (New):** The method of Claim 19, wherein the exterior surfaces on which the hinge is molded comprise a side of the cover and a side of the base, wherein the sides of the cover and the base are adjacent in the enclosure.

**Claim 22 (New):** The method of Claim 21, wherein the hinge extends continuously along substantially an entire length of the sides.

**Claim 23 (New):** The method of Claim 19, wherein the flexible material of the hinge comprises a plastic and wherein the hinge is configured to allow the cover to be closed upon the base and later removed a distance from the base at least five times prior to losing function or structural integrity.

**Claim 24 (New):** The method of Claim 19, wherein the base and the cover are formed of a plastic that includes a non-plastic filler that is a conductive material or has an electro-magnetic shielding characteristic.

**Claim 25 (New):** The method of claim 19, wherein the base is formed of a plastic and comprises a conductive grounding structure within the plastic and at least one structural feature for receiving the spindle motor and the head stack assembly.

**Claim 26 (New):** A method of manufacturing a disk drive having a head disk assembly within a hinged enclosure, comprising:

providing a plastic base assembly comprising four sides extending from a base plate;

providing a plastic cover assembly comprising four sides extending from a cover plate;

connecting the base assembly to the cover assembly by attaching a plastic hinge to an exterior surface of one of the sides of the base assembly and to an exterior surface of one of the sides of the cover assembly to form a hinged enclosure, wherein the hinge is flexible and allows movement of the cover assembly relative to the base assembly; and

attaching at least portions of a head disk assembly to the base plate,

Serial No. 10/774,143  
Reply to Office Action of November 21, 2005

wherein the base plate comprises one or more structural elements for receiving the attached portions of the head disk assembly.

**Claim 27 (New):** The method of claim 26, wherein the hinge extends continuously along an entire length of the sides of the base assembly and the cover assembly to which it is attached.

**Claim 28 (New):** The method of claim 26, wherein the plastics of the base assembly and the cover assembly include a non-plastic filler that has an electromagnetic shielding characteristic.

**Claim 29 (New):** The method of claim 26, wherein the base plate comprises a conductive grounding plate.

**Claim 30 (New):** The method of claim 26, wherein the plastic hinge is configured to allow the cover assembly to be moved to abut the base assembly and later moved a distance away from the base assembly at least five times prior to losing structural integrity.

**Claim 31 (New):** The method of claim 26, wherein the attaching of the plastic hinge comprises insert molding.